

Work Order ID 69656

Monday, May 16, 2011 8:56:03 AM



Page 1

Item ID: D412-630-031

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 5/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 120516

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG003

8 u105/27

JF for BG 11-5-26

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

EF 11/05/26 (1)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

****ensure tension to retract step is 11 to 18 lbs ****

8 u105/26

71
44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69656

Monday, May 16, 2011 8:56:03 AM

Page 3

Item ID: D412-630-031

Accept

Setup Start

Revision ID:

Stop

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 5/16/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/30

MF
11-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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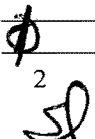


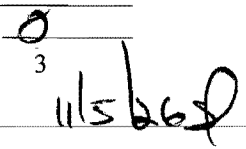
Monday, May 16, 2011 8:56:09 AM

Page 1

**Required Date:** 5/27/2011

Required Qty: 1.00

Comments:	IPP REV. A	05.11.21	NEW ISSUE	EC
	IPP REV. B	05.12.19	updated pick list	EC
	IPP REV. C	07.11.12	ecn 1019,no chg	EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 		Purchased	No			130	Each	26.0000	1				
NUT													
				<u>Location</u>						<u>Loc Qty</u>			
				ST324						26			
				117442						26			
AN310-5 		Purchased	No			130	Each	30.0000	2				
NUT													
				<u>Location</u>						<u>Loc Qty</u>			
				ST324						30			
				114830						30			
AN3C5A 		Purchased	No			130	Each	1,324.000	3				
Bolt													
				<u>Location</u>						<u>Loc Qty</u>			
				FP-A						7			
				115835						7			
				ST350						1317			
				115422						49			
				116419						368			
				116549						100			
				117343						500			
				117508						300			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 2

Work Order ID: 69656

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN44-C12

Purchased No

130 Each

28.0000

1



eyebolt

Location

Loc Qty

Loc Code

ST362

28

114669

8

117616

20

AN4C15

Purchased No

130 Each

2.0000

1



BOLT

Location

Loc Qty

Loc Code

ST358

2

114669

2

AN5C11

Purchased No

130 Each

38.0000

1



BOLT

Location

Loc Qty

Loc Code

ST337

38

113950

8

114801

30

AN5C15

Purchased No

130 Each

32.0000

1



BOLT

Location

Loc Qty

Loc Code

ST338

32

114669

12

117616

20

AN960C10

NAS1149C0363
R

Purchased No

130 Each

0.0000

7



WASHER



1114742 11/5/2011

Monday, May 16, 2011 8:56:10 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 69656

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C516

Purchased

No

130

Each

44.0000



WASHER

Location

Loc Qty

Loc Code

ST347

44

102842

44

D3454-1

Manufactured

No

130

Each

25.0000



Bushing

Location

Loc Qty

Loc Code

ST054

25

58555

25

D3454-3

Manufactured

No

130

Each

20.0000



Bushing

Location

Loc Qty

Loc Code

ST058

20

56420

20

D3454-5

Manufactured

No

130

Each

1.0000



Bushing

Location

Loc Qty

Loc Code

ST054

1

58556

1

D3455-1

Manufactured

No

130

Each

7.0000



Spacer

Location

Loc Qty

Loc Code

ST054

7

59469

7

Monday, May 16, 2011 8:56:11 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 69656

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3455-3

Manufactured No

130 Each

6.0000

2



Spacer

Location

Loc Qty

Loc Code

ST054

6

58559

6

Manufactured No

130 Each

3.0000

1

D3462-041



Bracket Assembly

Location

Loc Qty

Loc Code

ST198A

3

60572

3

Purchased No

130 Each

732.0000

3

MS21043-3



Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

ST301

652

112314

652

Purchased No

130 Each

43.0000

2

MS24665-227



COTTER PIN

Location

Loc Qty

Loc Code

ST309

43

113845

43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Monday, May 16, 2011 8:56:11 AM

Page 5

Work Order ID: 69656

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-229

Purchased

No

130

Each

133.0000

2

2

COTTER PIN

Location

Loc Qty

Loc Code

ST309

133

111041

133

Purchased

No

130

Each

128.0000

1

1

NAS1515H5

Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

88

109430

88

Manufactured

No

110

Each

1.0000

1

1

D3463-041

Step Weldment Assembly

Location

Loc Qty

Loc Code

ST494

1

56064

1

Manufactured

No

110

Each

0.0000

1

1

D3443-043

Strut Weldment Assembly

D3443-041

Manufactured

No

110

Each

5.0000

1

1

Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST198A

5

56061

3

68465

2

Monday, May 16, 2011 8:56:11 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 69656

Parent Item: D412-630-031

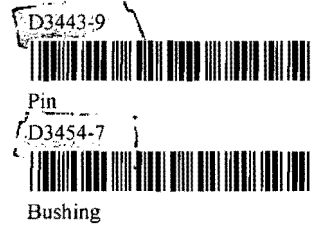
Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00



Manufactured No

110 Each 0.0000

2

2

B68475 (2X)

EP 11/05/26

Manufactured No

110 Each 12.0000

2

2

EP 11/05/26

Location

Loc Qty

Loc Code

ST054

12

59256

12

2

Manufactured No

110 Each 7.0000

2

2

EP 11/05/26

Location

Loc Qty

Loc Code

ST054

7

59469

7

2

Manufactured No

110 Each 23.0000

1

1

EP 11/05/26

Location

Loc Qty

Loc Code

ST054

23

46134

23

1

Purchased No

110 Each 31.0000

2

2

EP 11/05/26

Location

Loc Qty

Loc Code

ST355

11

114801

11

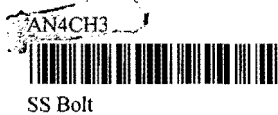
2

ST357

20

117616

20



Monday, May 16, 2011 8:56:12 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 16, 2011 8:56:12 AM

Page 7

Work Order ID: 69656

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00



BOLT

Purchased

No

110

Each

44.0000

1

1

Location

Loc Qty

Loc Code

ST357

25

117688

25

ST358

19

114669

19



EP 11/05/26



NUT

Purchased

No

110

Each

26.0000

1

1

Location

Loc Qty

Loc Code

ST324

26

117442

26



EP 11/05/26



NUT

Purchased

No

110

Each

46.0000

1

1

Location

Loc Qty

Loc Code

ST324

46

114784

46



EP 11/05/26



COTTER PIN

Purchased

No

110

Each

43.0000

1

1

Location

Loc Qty

Loc Code

ST309

43

113845

43



EP 11/05/26

Monday, May 16, 2011 8:56:12 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Monday, May 16, 2011 8:56:12 AM

Work Order ID: 69656



Parent Item: D412-630-031



Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-302

Purchased

No

110

Each

209.0000

1

1



Cotter Pin



EP 5/11/05/20

Location

Loc Qty

Loc Code

ST309

9

113644

9

ST357

200

117460

200

1

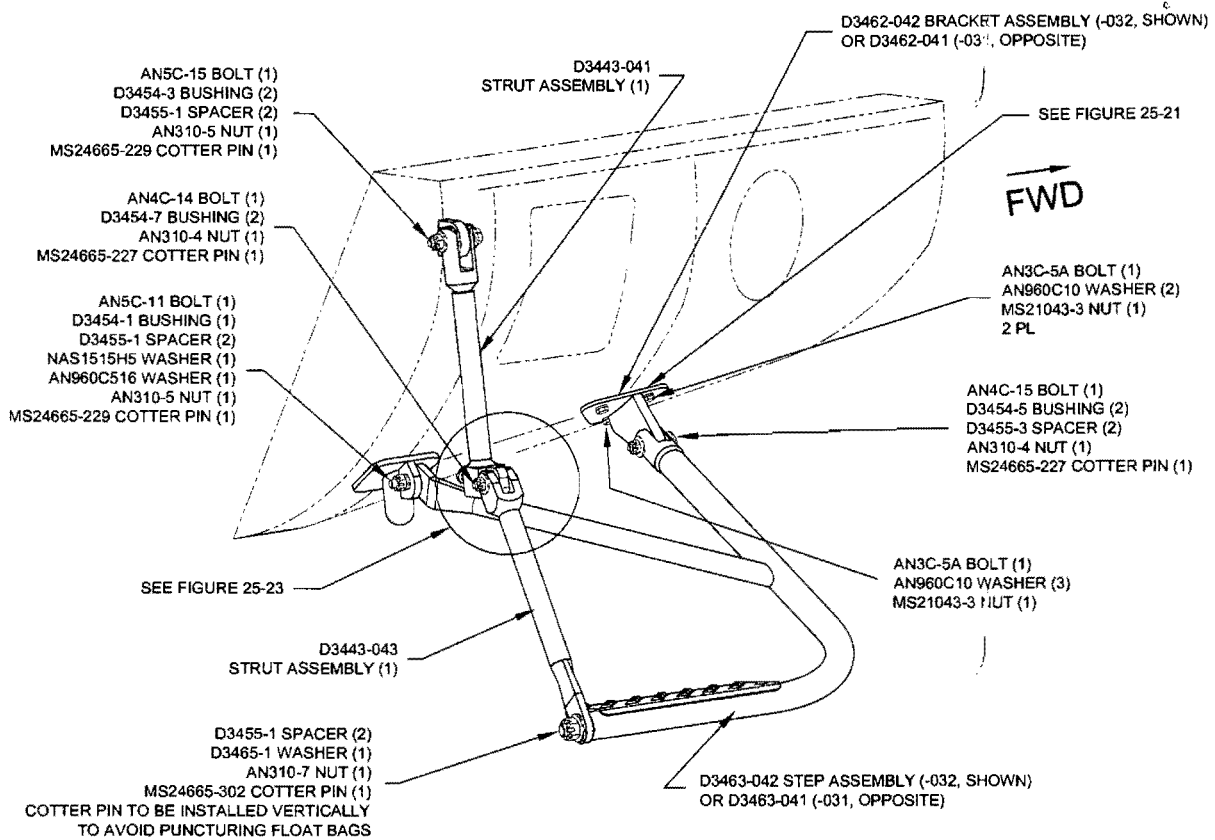
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

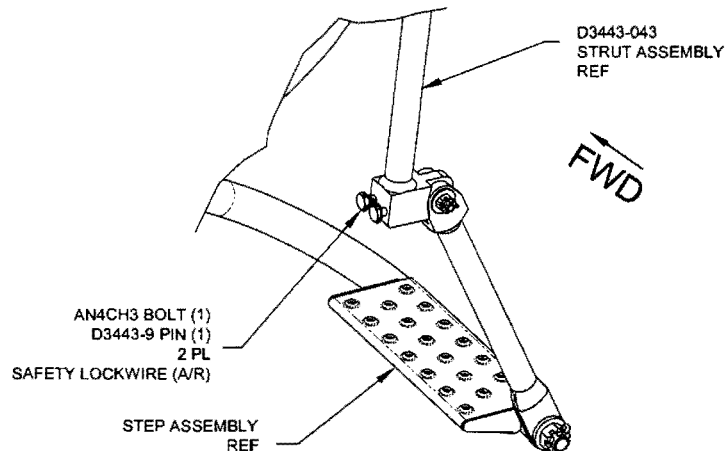
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**

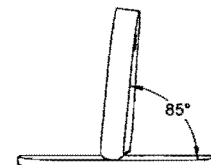
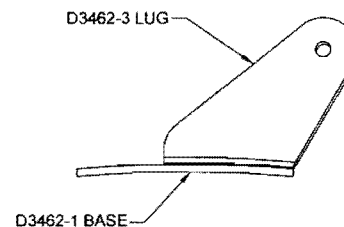
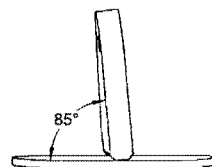
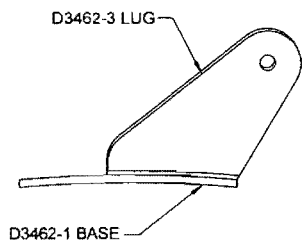
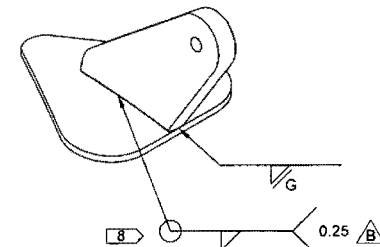
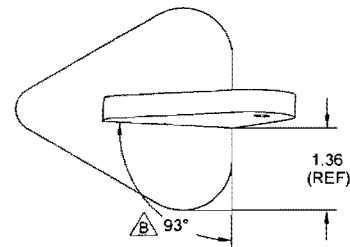
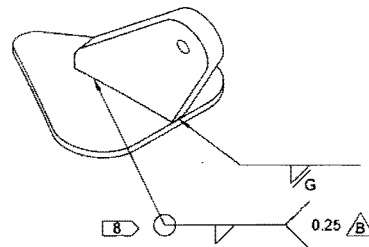
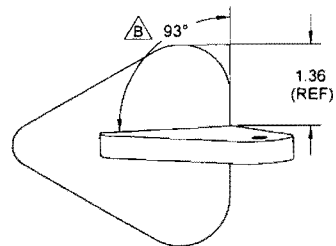


**FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**

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Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER -2
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1	1	D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT -1
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034TM HELI-ACCESS-STEP



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.24		

RELEASED
06.07.07 1/20

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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TITLE BRACKET ASSEMBLY	SCALE 1:2
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REFERENCE ONLY

